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D3564-5

Job Sheet 196591



Part No: D3564-5

Job Qty: 12 pcs

Part Name: Wearplate Center



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 6/17/19

Job Tracking No:

Due Date: 7/5/19

Created By: Marie Lajeunesse

Type: Stock

Description:

Note: DWG REV E IPP Rev:A New Issue 07-03-08 ec IPP Rev:B As per Rev C 07-07-09 JLM IPP Rev:C As per Rev D 07-09-09 JLM Verified By:EC IPP Rev D added DT# 08.04.21 DD Verified by EC

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs		7/5/19	0.17	2.41	Waterjet - Flow		2019/07/30
120	QC 8	12 pcs		7/5/19	0.00	0.00	QC 8 - 12		
							QC 8 - 14		
							QC 8 - 17		
							QC 8 - 20		
							QC 8 - 25		
							QC 8 - 3		
							QC 8 - 32		
							QC 8 - 33		
							QC 8 - 35		
							QC 8 - 39		
							QC 8 - 4		
							QC 8 - 44		
							QC 8 - 45		
							QC 8 - 49		
							QC 8 - 58		
							QC 8 - 8		
							QC 8 - 9		
							QC 8 - 68		
							QC 8 - 67		
							QC 8 - 1 (A)		
							QC 8 - 47		
							QC 8 - 40		JUL 31 2019
							QC 8 - 52		
							QC 8 - 23		
							QC 8 - 57		
130	Small Fab - Brake NC - B4B	12 pcs		7/5/19	0.25	0.60	Small Fab - Brake - 1 - B4B		DAS 30 9-89
							Small Fab - Brake - 2 - B4B		AUG 14 2019

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				Small Fab - Brake - 3 - B4B	610Z 51 90V
140 QC 5	12 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					DAS
					AUG 15 2019 40
					AL 17-8-16 9-89
150 Spray Paint - 2 - B4B	12 pcs	7/5/19	0.00 0.62	Spray Paint - 1 - B4B	
				Spray Paint - 2 - B4B	
				Spray Paint - 3 - B4B	
				Spray Paint - 4 - B4B	
160 QC X	12 pcs	7/5/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	DAS
				QC 5 - 58	81
				QC 5 - 68	9-89
				QC 5 - 9	
				QC 5 - 50	
				QC 5 - 30	
				QC 5 - 40	
					AUG 19 2019
170 Packaging 3-1 - Stock - B4B	12 pcs	7/5/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	FP-002
				Packaging 3 - 16 - B4B	AL 19-8-16
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	

				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	
				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
180 QC 21 - SA	12 pcs	7/5/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	
				QC 21 - SA - 53	
Part Op 120 - (QC8- Inspect parts - second check) Descriptions: 130 - (Form as per dwg) 140 - (QC5- Inspect part completeness to step on W/O) 150 - (Spray Paint / NDT Room) <u>S200412</u> 160 - (QC5- Inspect part completeness to step on W/O) 170 - (Identify as per dwg & Stock Location: _____) 180 - (QC21- Final Inspection - Work Order Release)					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
M304S16GA	304/316 Sheet .063	18 sf (1.5 ea)	100-Waterjet - Flow - 1	<u>S179460</u>	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	M304S16GA	18	295	0	

AUG 19 2019

AUG 20 2019

DAS
77
9-89

Part Specifications					
Spec No	Description	Target/Tolerance	Limits	Type	Special Comments
1	Wearshoe	43.500inches $\pm$ 0.030	43.530 43.470		
2	Wearshoe	6.750inches $\pm$ 0.030	6.780 6.720		
3	Wearshoe	10.000inches $\pm$ 0.030	10.030 9.970		
4	Wearshoe	20.000inches $\pm$ 0.030	20.030 19.970		
5	Wearshoe	30.000inches $\pm$ 0.030	30.030 29.970		
6	Wearshoe	2.500inches $\pm$ 0.030	2.530 2.470		
7	Wearshoe	3.227inches $\pm$ 0.010	3.237 3.217		
8	Wearshoe	38.500inches $\pm$ 0.010	38.510 38.490		
9	Wearshoe	5.500inches $\pm$ 0.010	5.510 5.490		
10	Wearshoe	2.500inches $\pm$ 0.030	2.530 2.470		
11	Wearshoe	2.432inches $\pm$ 0.010	2.442 2.422		
12	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
13	Wearshoe	0.300inches $\pm$ 0.010	0.310 0.290		
14	Wearshoe	0.188inches $\pm$ 0.005 - 0.001	0.193 0.187		
15	Wearshoe	0.375inches $\pm$ 0.010	0.385 0.365		
16	Wearshoe	0.063inches $\pm$ 0.010	0.073 0.053		

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Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
				Lead hand / Supervisor	
				QC / QA Coordinator	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐		FAULT CATEGORY ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					

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AEROSPACE

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Container No: S201529



Part: D3564-5

Job No: 196591

Serial No/Batch: S201529

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

Date: 07/20/19